



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 170981



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 3/2/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-2-20
100	Large Fab	1 pcs	3/1/18	3/1/18	0.00	10.00	Large Fab 1		CPC 18-02-23
110	QC	1 pcs	3/1/18	3/1/18	0.00	0.00	QC9		CPC
120	QC	1 pcs	3/1/18	3/1/18	0.00	0.00	QC5		CPC
125	HandFinish	1 pcs	3/1/18	3/1/18	0.00	0.29	HandFinish2		B.F.B. 18-02-26
130	Powdercoat	1 pcs	3/1/18	3/1/18	0.00	0.93	Powdercoat2		BR 18-2-26
135	Packaging	1 pcs	3/1/18	3/1/18	0.00	0.00	Packaging1		UL 18-2-27
140	QC	1 pcs	3/1/18	3/1/18	0.00	0.00	QC3		UL 18-2-27
150	HandFinish	1 pcs	3/2/18	3/2/18	0.00	0.50	HandFinish4		UL 18-2-27
160	QC	1 pcs	3/2/18	3/2/18	0.00	0.00	QC5		UL 18-2-27
170	Packaging	1 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-2		UL 18-2-27
180	QC21-SA	1 Ea	3/2/18	3/2/18	0.00	0.00	QC21		21 FEB 27 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ****take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M.138467. START: 12:00 O.V. 1375° FINISH: 12:15. M.U. 955

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5036037
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5041355
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5034377
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5032655
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5037519
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5030724
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5041737
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5040550
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5036080
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5031312
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5041136
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5038112

D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

8039317
5042459
5042462
5036909
5041893

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	52	0
	D3913-1	1	11	0
	D3913-15	1	28	0
	D3913-3	1	14	0
	D3913-7	2	15	0
	D3913-9	1	13	0
	D3916-041	2	10	0
	D3916-5	3	24	0
	D4016-1	3	32	0
	D4017-7	3	42	0
	D4017-9	2	16	0
	D4020-11	2	12	0
	D4021-1	3	23	0
	D4034-041	1	6	0
	D4034-043	1	8	0
	D4672-1	2	11	0
	M304EX0.75-16F	33	903	0
150-HandFinish	AN3-10A 5041477	6	157	0
	D2931 F86435-1	2	1,156	0
	D4021-5 50415376	2	19	0
	MS20600-AD4W3 5019431	2	187	0
	MS21042L3 50372841	6	2,693	0
	NAS1149F0332P 5020603	12	5,387	0

Part Specifications

Specifications could not be found.

001210

Master Unit 000953



Job No 171887



Container No: S043635



Part: D3913 - 041

Job No: 170981

Serial No/Batch: S043635

Revision: D4020, D3913

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/20/18